

Del 1.25

Work Order ID 73431



Thursday, September 01, 2011 7:21:29 AM

Page 1

Item ID: D3417-9

Accept



Setup Start



Revision ID:

Item Name: Washer

Stop



Start Date: 8/31/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: CD

Date: 11/09/01 Tooling: _____ Date: _____

Run Start



QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3417	F

100



Hardinge CNC LATHE SMALL

0.00

20 0

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Folio FA954

Folio Rev: E

Dwg D3417 Rev: E

2-Deburr

SL W10/3

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

SL 11/10/13

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73431

Thursday, September 01, 2011 7:21:29 AM



Page 2

Item ID: D3417-9

Accept



Setup

Start



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Stop



Start Date: 8/31/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: 53

0.00

count

11/10/13

SF 200

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W10/15/13

CMF
11-10-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, September 01, 2011 7:21:26 AM

Page 1

Work Order ID: 73431



Parent Item: D3417-9



Parent Item Name: Washer

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: Ipp Rev:A New Issue 10-08-03 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.2500 DELRIN ROUND BAR 1.25"		Purchased		No			f	14.4680		0.623158		10/03	

Location	Loc Qty	Loc Code
MAT055 114586	14.468 14.468	63AF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	73431
Description: Washer	Part Number:	D3417-9
Inspection Dwg: D3417 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by: <u>SA</u>	Audited by: <u>RP</u>	Preliminary Approval:
Date: <u>11/10/13</u>	Date: <u>11. 10. 13</u>	Date:

Rev	Date	Change	Revised by	Approved
A	10.11.08	New Issue	KJ	

8

7

6

5

4

3

2

1

D

D

C

C

B

B

A

A

D3417-1 WASHER

SHOP COPY
 RETURN TO
 ENGINEERING
UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 73431
CL11109101

NOTES:

- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL, ROD
 REF DART SPEC M-DELRIN-R
 OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, BAR
 REF DART SPEC M-DELRIN-B
 OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, SHEET
 REF DART SPEC M-DELRIN-S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3417-1, 0.020 lbs
 D3417-3, 0.010 lbs
 D3417-5, 0.010 lbs
 D3417-7, 0.010 lbs
 D3417-9, 0.004 lbs

D3417-3 WASHER

F

E

D

C

B

A

REV.

DESCRIPTION

F

SC

E

RF

D

AJS

C

PH

B

PH

A

PH

REV.

DATE

D3417-5 WASHER

F

DRAWN

CHECKED

MFG. APPR.

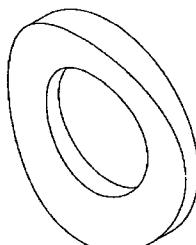
APPROVED

DE APPR.

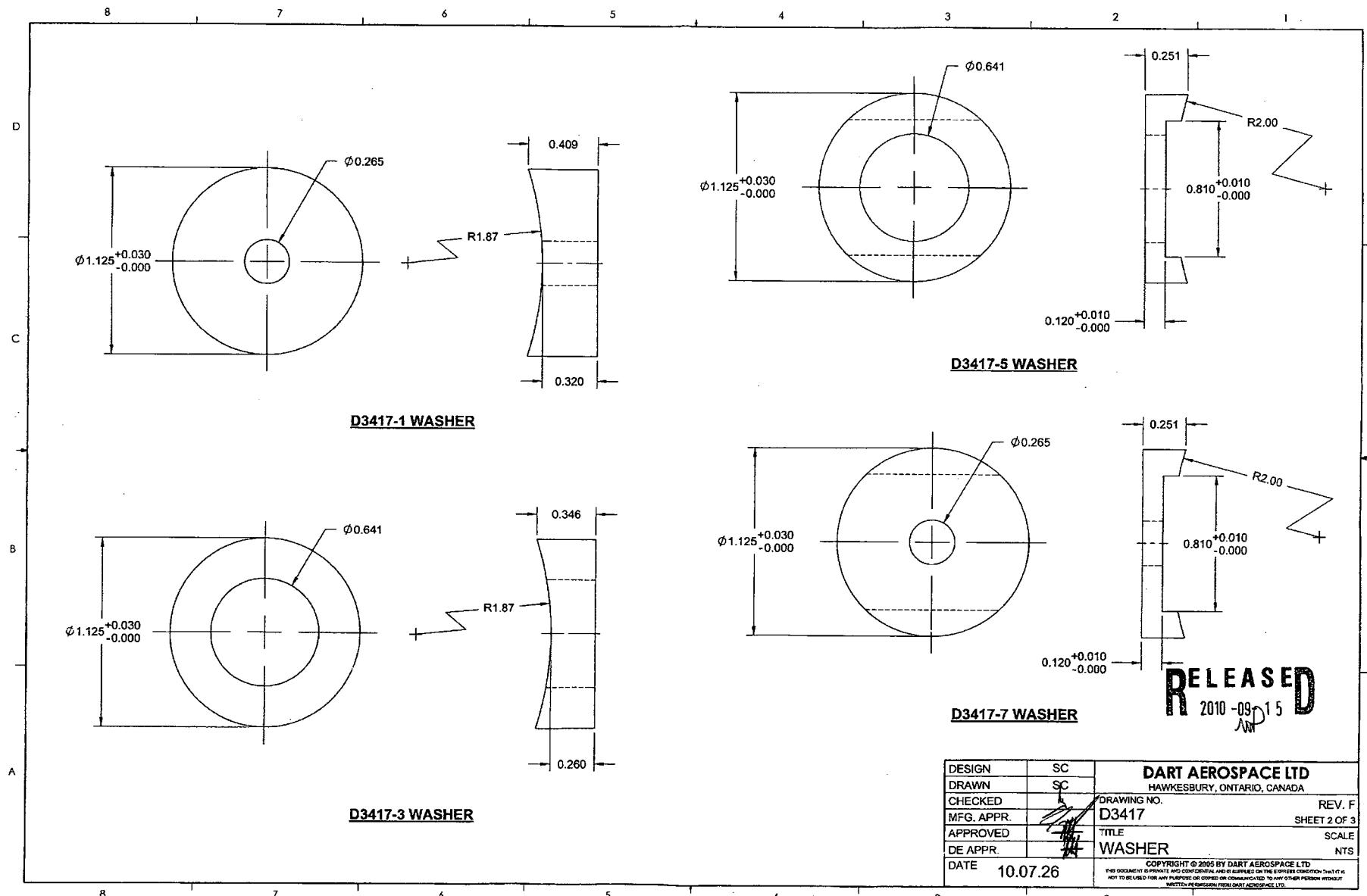
DATE

D3417-7 WASHER

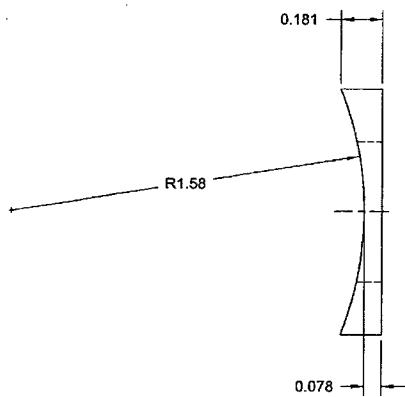
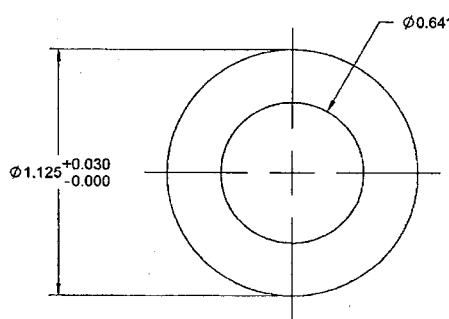
RELEASED
 2010-09-15
CL



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D3417-9 WASHER

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R 2010-09-15
W

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